



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

13643

D5469-1

Job Sheet 193216



Part No: D5469-1

Job Qty: 10 pcs

Part Name: Saddle, Aft, In



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 4/9/19

Job Tracking No: 13643

Due Date: 5/16/19

Created By: Dara Macdonald

Type: SOLD

Description:

Note: IPP Rev.A 17.07.12 New issue DP Verify DD. IPP REV:B 17.11.03 AS PER DWG REV.A DD VERF:DP

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	HAAS 4 Axis	10 pcs	5/16/19		0.00	19.81	HAAS - 1		Sebl/VH 19/5/19
							HAAS - 2		
							HAAS - 3		
							HAAS - 4		
120	QC 2	10 pcs	5/16/19		0.00	0.00	QC 2 - 1		VH 19/5/19
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		
							QC 2 - 57		
							QC 2 - 62		
							QC 2 - 63		



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Container No: S181760



Part: D5469-1

Job No: 193216

Serial No/Batch: S181760

Revision: A

Inspector:

Exp Date:

Instructions: Various STC's

Date: 05/16/19

Plex 4/9/19 1:35 PM Dart.Macdonald.Dara

				QC 2 - 8	
				QC 2 - 66	
				QC 2 - 64	
				QC 2 - 65	
				QC 2 - 5	
				QC 2 - 71	
130	QC 8	10	5/16/19	0.00 0.00	QC 8 - 12
		pcs			QC 8 - 14
					QC 8 - 17
					QC 8 - 20
					QC 8 - 25
					QC 8 - 3
					QC 8 - 32
					QC 8 - 33
					QC 8 - 35
					QC 8 - 39
					QC 8 - 4
					QC 8 - 44
					QC 8 - 45
					QC 8 - 49
					QC 8 - 58
					QC 8 - 8
					QC 8 - 9
					QC 8 - 68
					QC 8 - 67
					QC 8 - 1 (A)
					QC 8 - 47
					QC 8 - 40
					QC 8 - 52
					QC 8 - 23
140	Handfinish - 1-1 Chemical-B4B	10	5/16/19	0.00 1.41	Handfinish - 1 - 1 - B4B
		pcs			Handfinish - 1 - 2 - B4B
					Handfinish - 1 - 3 - B4B
					Handfinish - 1 - 4 - B4B
					Handfinish - 1 - 5 - B4B
					Handfinish - 1 - 6 - B4B
					Handfinish - 1 - 7 - B4B
					Handfinish - 1 - 8 - B4B
					Handfinish - 1 - 9 - B4B
					Handfinish - 1 - 10 - B4B
					Handfinish - 1 - 11 - B4B
					Handfinish - 1 - 12 - B4B
					Handfinish - 1 - 13 - B4B
					Handfinish - 1 - 14 - B4B
					Handfinish - 1 - 15 - B4B
					Handfinish - 1 - 16 - B4B

sum 19/05/19

SA

MAY 22 2019

					Handfinish - 1 - 17 - B4B	
					Handfinish - 1 - 18 - B4B	
					Handfinish - 1 - 19 - B4B	
					Handfinish - 1 - 20 - B4B	
					Handfinish - 1 - 21 - B4B	
					Handfinish - 1 - 22 - B4B	
150	Spray Paint - 2 - B4B	10 pcs	5/16/19	0.00 0.24	Spray Paint - 1 - B4B	• AS 19-5-23
					Spray Paint - 2 - B4B	
					Spray Paint - 3 - B4B	
					Spray Paint - 4 - B4B	
160	QC 14	10 pcs	5/16/19	0.00 0.00	QC 14 - 15	
					QC 14 - 2	
					QC 14 - 34	
					QC 14 - 41	
					QC 14 - 51	
					QC 14 - 58	
					QC 14 - 59	
					QC 14 - 9	
					QC 14 - 68 Um AT	
					QC 14 - 40	
					QC 14 - 19	
163	Outsource - 11 - Paint	10 pcs	5/16/19		ATE003-VC 2	NOT REQUIRED
165	Packaging 2-1 - Receive - B4B	10 pcs	5/16/19	0.00 0.00	Packaging 2 - 1 - B4B	
					Packaging 2 - 2 - B4B	
					Packaging 2 - 3 - B4B	
					Packaging 2 - 5 - B4B	
					Packaging 2 - 4 - B4B	
					Packaging 2 - 6 - B4B	
					Packaging 2 - 7 - B4B	
					Packaging 2 - 8 - B4B	
					Packaging 2 - 9 - B4B	
					Packaging 2 - 10 - B4B	
					Packaging 2 - 11 - B4B	
					Packaging 2 - 12 - B4B	
					Packaging 2 - 13 - B4B	
					Packaging 2 - 14 - B4B	
					Packaging 2 - 15 - B4B	
					Packaging 2 - 16 - B4B	
					Packaging 2 - 17 - B4B	
					Packaging 2 - 18 - B4B	
					Packaging 2 - 19 - B4B	
					Packaging 2 - 20 - B4B	
					Packaging 2 - 21 - B4B	
					Packaging 2 - 22 - B4B	

MAY 30 2019
DAS 68
9-89 MAY 30 2019

NOT REQUIRED

					Packaging 2 - 23 - B4B	
					Packaging 2 - 24 - B4B	
					Packaging 2 - 25 - B4B	
					Packaging 2 - 26 - B4B	
					Packaging 2 - 27 - B4B	
					Packaging 2 - 28 - B4B	
					Packaging 2 - 29 - B4B	
					Packaging 2 - 30 - B4B	
					Packaging 2 - 31 - B4B	
					Packaging 2 - 32 - B4B	
					Packaging 2 - 33 - B4B	
					Packaging 2 - 34 - B4B	
					Packaging 2 - 35 - B4B	
					Packaging 2 - 36 - B4B	
167	QC 6	10 pcs	5/16/19	0.00 0.00	QC 6 - 9	DAS
					QC 6 - 68	MAY 30 2019 68
					QC 6 - 61	9-89
170	Packaging 3-1 - Stock - B4B	10 pcs	5/16/19	0.00 0.00	Packaging 3 - 1 - B4B	
					Packaging 3 - 2 - B4B	
					Packaging 3 - 3 - B4B	
					Packaging 3 - 4 - B4B	
					Packaging 3 - 5 - B4B	DAS
					Packaging 3 - 6 - B4B	28
					Packaging 3 - 7 - B4B	9-89
					Packaging 3 - 8 - B4B	
					Packaging 3 - 9 - B4B	
					Packaging 3 - 10 - B4B	
					Packaging 3 - 11 - B4B	
					Packaging 3 - 12 - B4B	
					Packaging 3 - 13 - B4B	
					Packaging 3 - 14 - B4B	
					Packaging 3 - 15 - B4B	
					Packaging 3 - 16 - B4B	
					Packaging 3 - 17 - B4B	
					Packaging 3 - 18 - B4B	
					Packaging 3 - 19 - B4B	
					Packaging 3 - 20 - B4B	
					Packaging 3 - 21 - B4B	
					Packaging 3 - 22 -	

					B4B	
					Packaging 3 - 23 - B4B	
					Packaging 3 - 24 - B4B	
					Packaging 3 - 25 - B4B	
					Packaging 3 - 26 - B4B	
					Packaging 3 - 27 - B4B	
					Packaging 3 - 28 - B4B	
					Packaging 3 - 29 - B4B	
					Packaging 3 - 30 - B4B	
					Packaging 3 - 31 - B4B	
					Packaging 3 - 32 - B4B	
					Packaging 3 - 33 - B4B	
					Packaging 3 - 34 - B4B	
					Packaging 3 - 35 - B4B	
					Packaging 3 - 36 - B4B	
180 QC 21 - SA	10 pcs	5/16/19	0.00	0.00	QC 21 - SA - 21	DAG 21
					QC 21 - SA - 70	9:55 JUN 03 2019
					QC 21 - SA - 53	

Part Op 100 - (HAAS CNC Vertical Machine) Program Batch No. 5181760 Double check by: SL 1-Machine Step No 1 per Descriptions: Folio FB548 and inspect per attached Dimension Sheets 2-Machine Step No 2 per Folio FB548 and inspect per attached Dimension Sheets 3-Machine Step No 3 per Folio FB548 and insp

120 - (QC2- Inspect parts off machine FAI/FAIB)

130 - (QC8- Inspect parts - second check)

140 - (Chemical Conversion Coat per QSI005 4.1)

150 - (Spray Paint / NDT Room) ***MASK HOLES PRIOR TO PRIME AND PAINT AS PER DWG NOTE 8*** 1-PRIME AS PER DWG AND QSI005 4.2.1.3.3 PRIMER BATCH: _____ 2-PAINT AS PER DWG AND QSI005 4.2.2.4 PAINT BATCH: _____

160 - (QC14- Inspect Spray Paint)

163 - ISSUE P/O: _____ ***MASK HOLES PRIOR TO PRIME AND PAINT AS PER DWG NOTE 8*** 1-PRIME AS PER DWG AND QSI005 4.2.1.3.3 PRIMER BATCH: 5163577 2-PAINT AS PER DWG AND QSI005 4.2.2.4 PAINT BATCH: 5179047 C OF C IS REQUIRED

165 - (Receive & Inspect for Damage & Mat'l Certs)

167 - (QC6- All purchased or subcontracted products)

170 - (Identify as per dwg & Stock Location: _____)

180 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D6101-005	Saddle Billet	10 pcs (1 ea)	100-HAAS 4 Axis	<u>5175542</u>

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-HAAS 4 Axis	D6101-005	10	72	0

Part Specifications

Specifications could not be found.

DART AEROSPACE LTD	Work Order: 193 210
Description: Saddle, Aft Outboard	Part Number: D5468-1 D5468-1
Inspection Dwg: D5469 Rev. A	Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D5469 Rev. A and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.438	0.443		0.438	0.438	0.438	0.438		
B	1.745	1.755		1.750	1.750	1.750	1.750		
C	3.495	3.505		3.500	3.500	3.500	3.500		
D	1.745	1.755		1.750	1.750	1.750	1.750		
E	7.990	8.010		7.998	7.999	7.997	7.998		
F	0.490	0.510		0.499	0.496	0.500	0.503		
G	0.257	0.262		0.258	0.258	0.258	0.258		
H	0.375	0.380		0.376	0.376	0.376	0.376		
I	0.490	0.510		0.500	0.500	0.5015	0.501		
J	1.174	1.184		1.179	1.179	1.179	1.179		
K	0.558	0.578		0.568	0.568	0.568	0.5675		
L	1.174	1.184		1.179	1.179	1.179	1.179		
M	1.365	1.375		1.370	1.370	1.370	1.370		
N	2.495	2.505		2.500	2.500	2.500	2.500		
O	4.119	4.129		4.124	4.124	4.124	4.124		
P	0.115	0.135		0.128	0.130	0.130	0.130		
Q	0.115	0.135		0.125	0.125	0.125	0.125		
R	0.240	0.260		0.255	0.256	0.255	0.255		
S	0.115	0.135		0.131	0.131	0.131	0.131		
T	0.178	0.198		0.188	0.188	0.188	0.188		
U	3.210	3.250		3.230	3.230	3.230	3.230		
V	0.230	0.250		0.242	0.241	0.242	0.2435		
W	0.115	0.135		0.134	0.133	0.134	0.134		
Z	0.352	0.372		0.367	0.366	0.365	0.365		
AA	0.470	0.530		0.500	0.500	0.500	0.500		
AB	0.615	0.635		0.622	0.623	0.623	0.623		
AC	0.053	0.073		0.067	0.068	0.064	0.064		
AD	0.240	0.260		0.255	0.255	0.256	0.256		
AE	1.500	1.520		1.510	1.510	1.510	1.510		
AF	0.115	0.135		0.130	0.130	0.130	0.130		
AG	0.240	0.280		0.254	0.260	0.260	0.260		
AH	0.240	0.260		0.254	0.254	0.255	0.255		
AI	2.000	2.020		2.000	2.000	2.000	2.000		
Accept/Reject									

Measured by:	
Date:	

Audited by:	mg
Date:	18/05/19

Rev	Date	Change	Revised by	Approved
A	18.05.30	New Issue	MG	mg

DART AEROSPACE LTD	Work Order: 193 216
Description: Saddle, Aft Outboard	Part Number: D5468-1 D5469-1
Inspection Dwg: D5469 Rev. A	Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D5469 Rev. A and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	15	26	37	48	By	Date
A	0.438	0.443		0.438	0.438	0.438	0.438		
B	1.745	1.755		1.750	1.750	1.750	1.750		
C	3.495	3.505		3.500	3.500	3.500	3.500		
D	1.745	1.755		1.750	1.750	1.750	1.750		
E	7.990	8.010		7.998	7.994	7.998	8.000		
F	0.490	0.510		0.5015	0.501	0.499	0.503		
G	0.257	0.262		0.258	0.258	0.258	0.258		
H	0.375	0.380		0.375	0.375	0.375	0.375		
I	0.490	0.510		0.500	0.501	0.500	0.500		
J	1.174	1.184		1.179	1.179	1.179	1.179		
K	0.558	0.578		0.568	0.568	0.5645	0.5675		
L	1.174	1.184		1.179	1.179	1.179	1.179		
M	1.365	1.375		1.370	1.370	1.370	1.370		
N	2.495	2.505		2.500	2.500	2.500	2.500		
O	4.119	4.129		4.124	4.124	4.124	4.124		
P	0.115	0.135		0.130	0.130	0.130	0.130		
Q	0.115	0.135		0.126	0.126	0.126	0.126		
R	0.240	0.260		0.254	0.255	0.256	0.256		
S	0.115	0.135		0.130	0.132	0.133	0.132		
T	0.178	0.198		0.188	0.188	0.188	0.188		
U	3.210	3.250		3.230	3.230	3.230	3.230		
V	0.230	0.250		0.242	0.242	0.242	0.243		
W	0.115	0.135		0.133	0.133	0.133	0.133		
X	0.352	0.372		0.365	0.365	0.366	0.365		
Y	0.470	0.530		0.500	0.500	0.500	0.500		
Z	0.615	0.635		0.623	0.624	0.624	0.623		
AA	0.053	0.073		0.062	0.062	0.065	0.065		
AB	0.240	0.260		0.255	0.255	0.257	0.2565		
AC	1.500	1.520		1.510	1.510	1.510	1.510		
AD	0.115	0.135		0.125	0.125	0.125	0.125		
AE	0.240	0.280		0.260	0.260	0.260	0.260		
AF	0.240	0.260		0.260	0.260	0.260	0.260		
AG	2.000	2.020		2.000	2.000	2.000	2.000		
Accept/Reject									

Measured by: 148
Date: 19/5/18

Audited by: J. M. L.
Date: 19/05/19

Rev	Date	Change	Revised by	Approved
A	18.05.30	New Issue	MG <i>mg</i>	<i>M</i>

DART AEROSPACE LTD	Work Order: 193 216
Description: Saddle, Aft Outboard	Part Number: D5468-1 D5469-1
Inspection Dwg: D5469 Rev. A	Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D5469 Rev. A and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	# 9	# 10	3	4	By	Date
A	0.438	0.443		0.438	0.438				
B	1.745	1.755		1.750	1.750				
C	3.495	3.505		3.500	3.500				
D	1.745	1.755		1.750	1.750				
E	7.990	8.010		8.000	8.001				
F	0.490	0.510		0.502	0.503				
G	0.257	0.262	✓	0.258	0.258				
H	0.375	0.380	✓	0.375	0.375				
I	0.490	0.510		0.506	0.491				
J	1.174	1.184	✓	1.174	1.179				
K	0.558	0.578		0.5675	0.5675				
L	1.174	1.184	✓	1.179	1.179				
M	1.365	1.375	✓	1.370	1.370				
N	2.495	2.505	✓	2.500	2.500				
O	4.119	4.129	✓	4.124	4.124				
P	0.115	0.135		0.130	0.130				
Q	0.115	0.135	✓	0.126	0.126				
R	0.240	0.260	✓	0.255	0.256				
S	0.115	0.135		0.132	0.133				
T	0.178	0.198	✓	0.188	0.188				
U	3.210	3.250	✓	3.230	3.230				
V	0.230	0.250		0.243	0.243				
W	0.115	0.135		0.134	0.134				
X	0.352	0.372		0.364	0.364				
Y	0.470	0.530	✓	0.500	0.500				
Z	0.615	0.635		0.624	0.624				
AA	0.053	0.073		0.065	0.065				
AB	0.240	0.260		0.257	0.2565				
AC	1.500	1.520	✓	1.510	1.510				
AD	0.115	0.135		0.125	0.125				
AE	0.240	0.280	✓	0.260	0.260				
AF	0.240	0.260		0.250	0.250				
AG	2.000	2.020	✓	2.000	2.000				
Accept/Reject									

Measured by: <i>VHJ</i>
Date: 19/5/18

Audited by: <i>mmf</i>
Date: 19/05/19

Rev	Date	Change	Revised by	Approved
A	18.05.30	New Issue	MG <i>mmf</i>	<i>A</i>